

Date: Friday, 01/02/2008 9:49:56 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: FLANGE ASS'Y		
Job Number	: 37142			Part Number	: D3651043		
Estimate Number	: 13032			Drawing Number	: D3651 REV.B U/R		
P.O. Number	:			Project Number	: N/A		
This Issue	: 01/02/2008 S.O. No. :			Drawing Revision	: B U/R		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 08/02/2008 Qty: 2 Um: Each		
Previous Run	: 36914						
Written By	:						
Checked & Approved By	:						
Comment	: Est Rev:A New Issue 07-09-27 DD verified by: EC						
	: Est Rev:B ECN 1113P 08-01-22 DD						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S26GA	304/316 0.018 SHEET
Comment: Qty.: 0.2573 sf(s)/Unit Total : 0.5145 sf(s) 304/316 SS sheet 26 ga (0.018" thick) Batch: <u>106996</u> <u>LB 8-2-4</u>		
(FOR D3651-7)		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3651 (D3651-7) Dwg Rev: <u>PRE L B</u> Prog Rev: <u>PRE. L B LB 8-2-4</u>		
2-Deburr if necessary IDENTIFY AS D3651-7 <u>LB 8-2-4</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<u>LB 8-2-4</u> Comment: INSPECT PARTS AS THEY COME OFF MACHINE		

4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>D3651-7</u> <u>08/01/08</u> <u>LB 8-2-4</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/02/2008 9:49:56 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLANGE ASS'Y

Job Number: 37142

Part Number: D3651043

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 M304S26GA 304/316 0.018 SHEET



Comment: Qty.: 0.2573 sf(s)/Unit Total : 0.5145 sf(s)

304/316 SS sheet 26 ga (0.018" thick)

Batch: 106996 B 8-2-4

(FOR D3651-5)

6.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3651 (D3651-5)

Dwg Rev: B

Prog Rev: B B 8-2-4

②

2-Deburr if necessary

Identify as D3651-5

B 8-2-4

7.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



B 8-2-4

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

8.0 QC8 SECOND CHECK



D3651-5

10812104 X2

Comment: SECOND CHECK

9.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form D3651-5 and D3651-7 as per Dwg D3651

180803 12 0

PTC

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10 08-03-13

11.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1

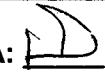


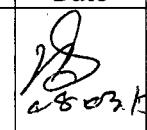
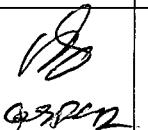
Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3651

PD 08-03-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3651-043 PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 08/03/14
QA: N/C Closed: _____ Date: _____

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/03/14	# 9.0	One D3651-51-7 Scrapped	 Oscar	destroy	 08/03/14	 08/03/14	 08/03/14	✓ 08/03/14

NOTE: Date & initial all entries

Date: Friday, 01/02/2008 9:49:56 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLANGE ASS'Y

Job Number: 37142

Part Number: D3651043

Job Number:



Seq. #:	Machine Or Operation:	Description :
12.0	QC9	VISUAL WELDING INSPECTION
13.0	QC5	INSPECT WORK TO CURRENT STEP
14.0	D36513	BASE
15.0	MS20427M33	Rivet
16.0	MS210603K	Nut Plate
17.0	CR352340/-02	RIVET
18.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
19.0	QC5	INSPECT WORK TO CURRENT STEP ENGINEERING APPROVAL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and stock

Location:

PP038103

1/8/18 0

(D)

21.0 QC21

FINAL INSPECTION/W/O RELEASE



08 03 18
08 03 18
J

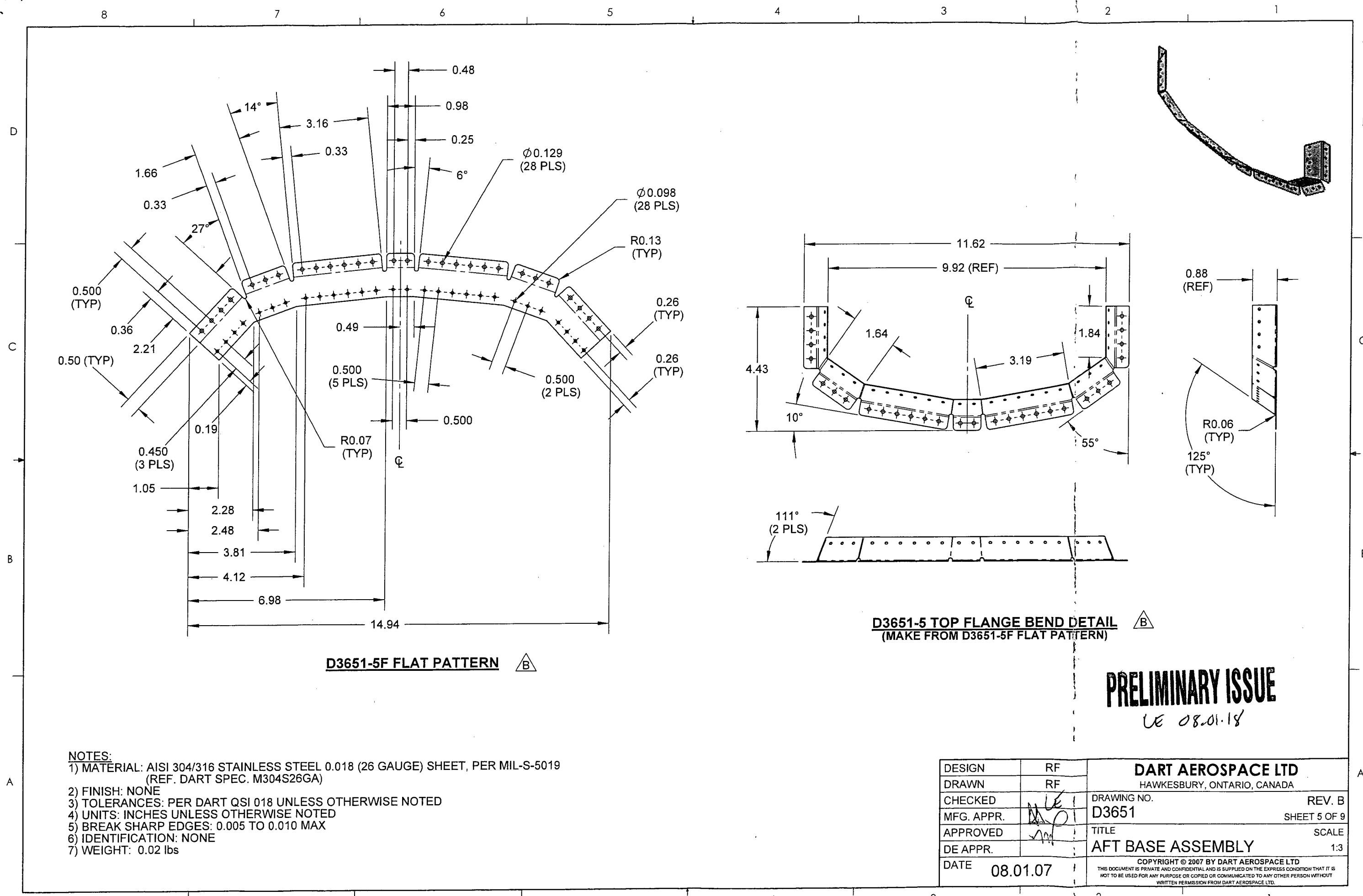
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

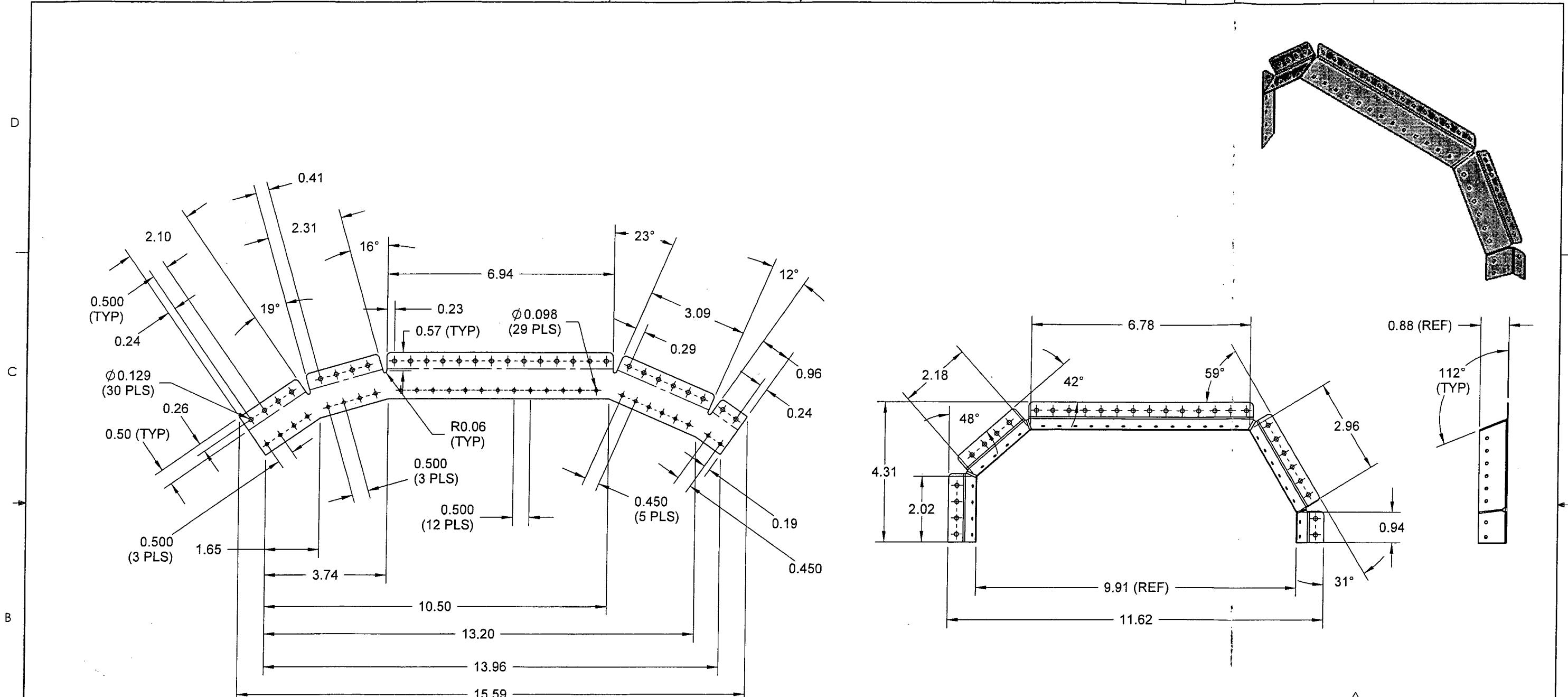


1/8/03.14

POSITIVE RECALL
EFFECTIVE 08/03/01 AUTH
RELEASED PU DATE 08/03/01



8 7 6 5 4 3 2 1



D3651-7 BOTTOM FLANGE BEND DETAIL
(MAKE FROM D3651-7F FLAT PATTERN) 

D3651-7F FLAT PATTERN 

PRELIMINARY ISSUE
LE 08-01-08

A

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	LE	DRAWING NO.
MFG. APPR.	MA	REV. B
APPROVED	MC	D3651
DE APPR.	MC	SHEET 6 OF 9
DATE	08.01.07	TITLE
		SCALE
		1:3
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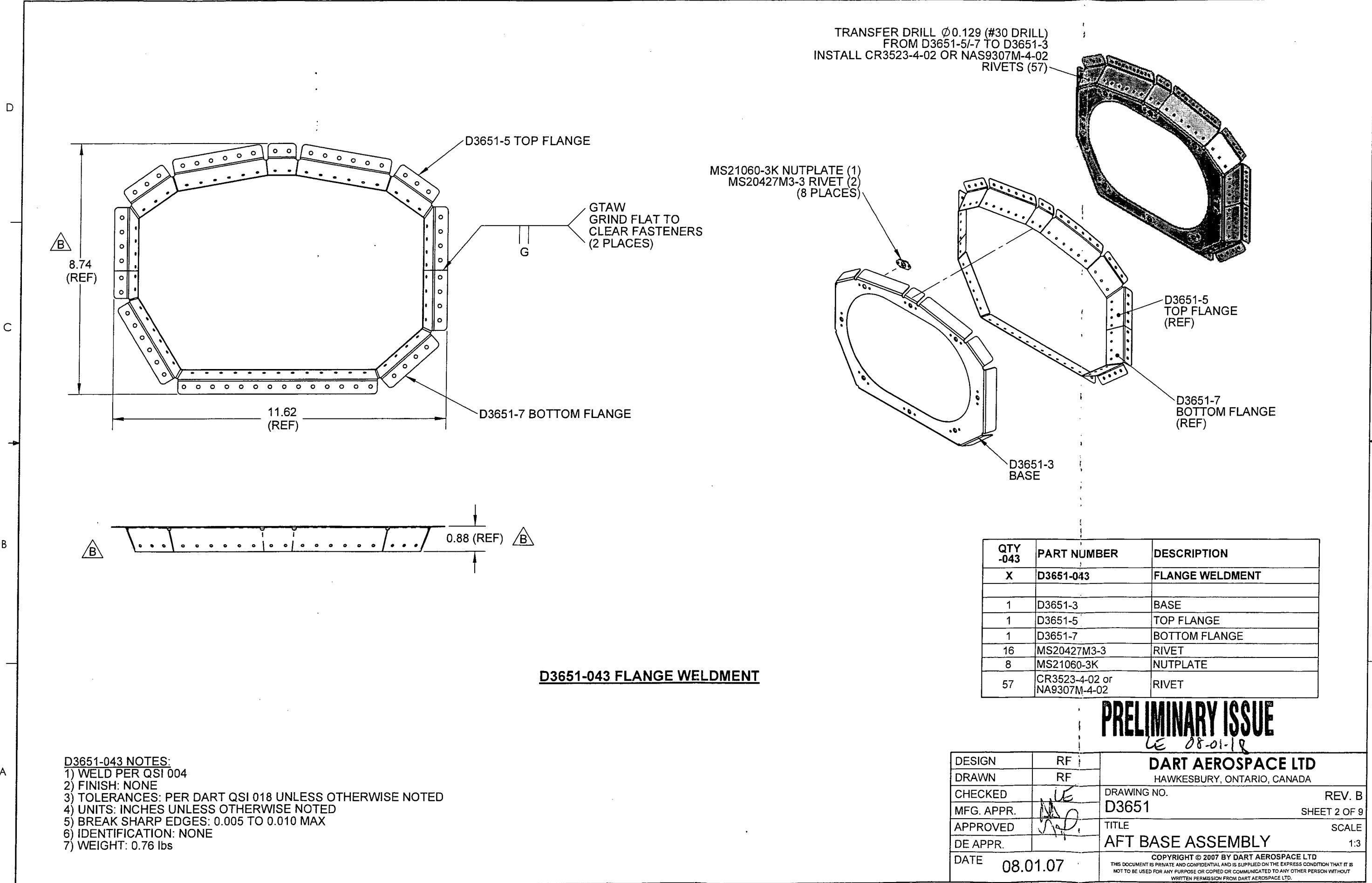
3

2

1

A

8 7 6 5 4 3 2 1



DART AEROSPACE LTD	Work Order:	37142
Description: FLANGE ASS'Y	Part Number:	D3651-7
Inspection Dwg: D3651-7 Rev: PPF 1		Page 1 of 1

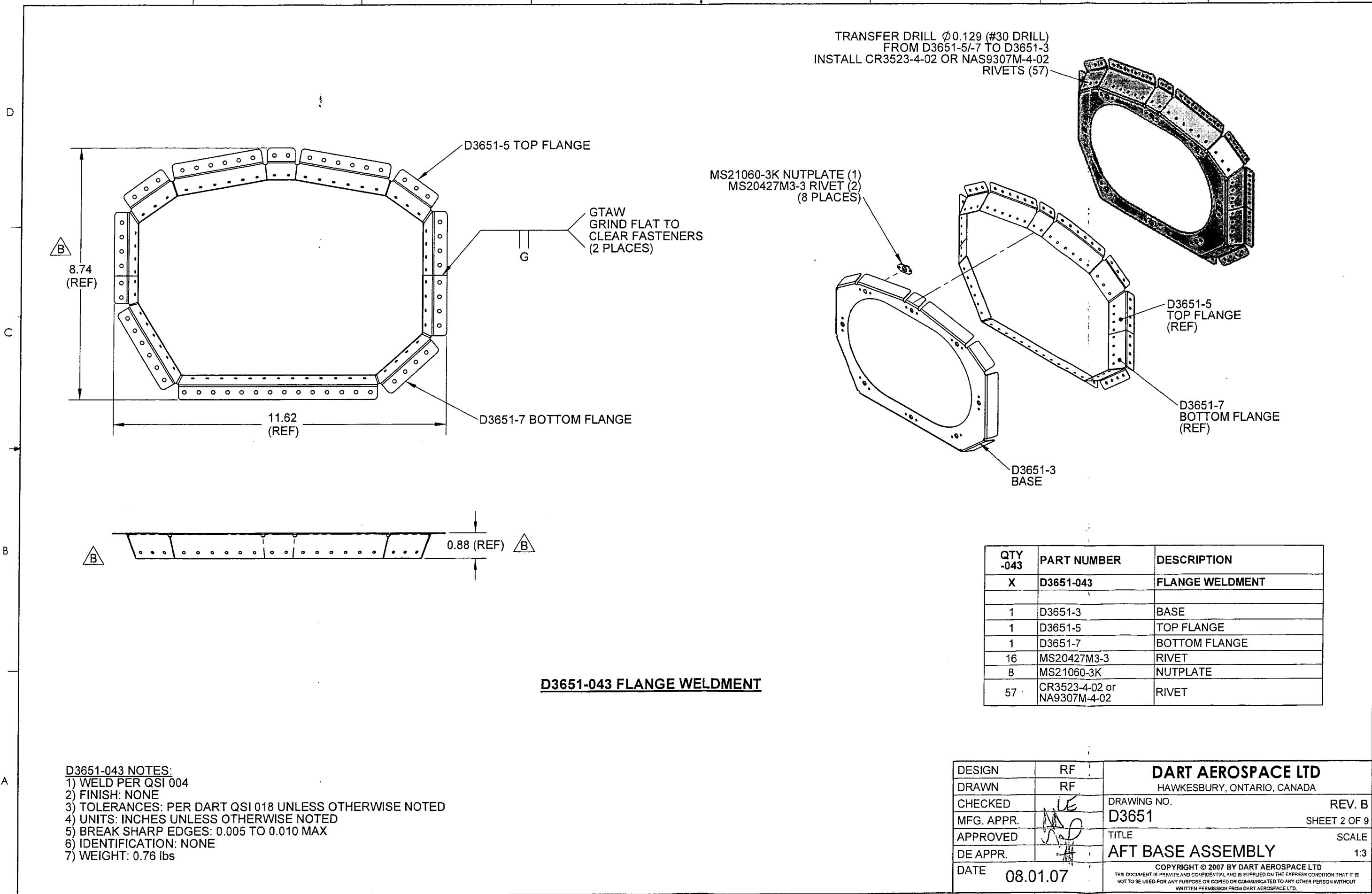
FIRST ARTICLE INSPECTION CHECKLIST

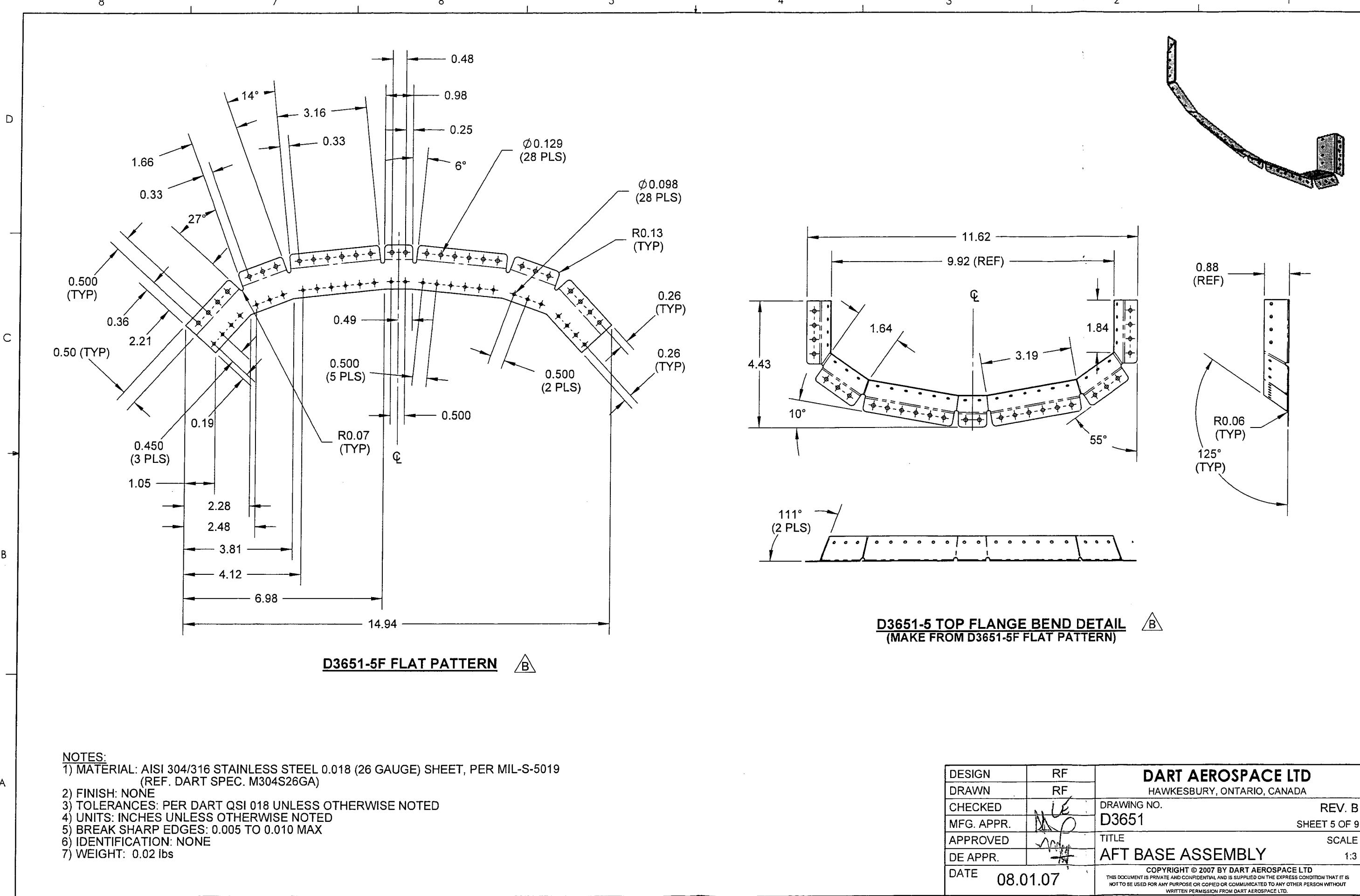
X First Article Prototype

Measured by: <u>IR</u>	Audited by: <u>W</u>	Prototype Approval: <u>LG</u>
Date: <u>8-2-11</u>	Date: <u>08/08/11</u> <u>08-08-11</u>	Date: <u>08-02-11</u>

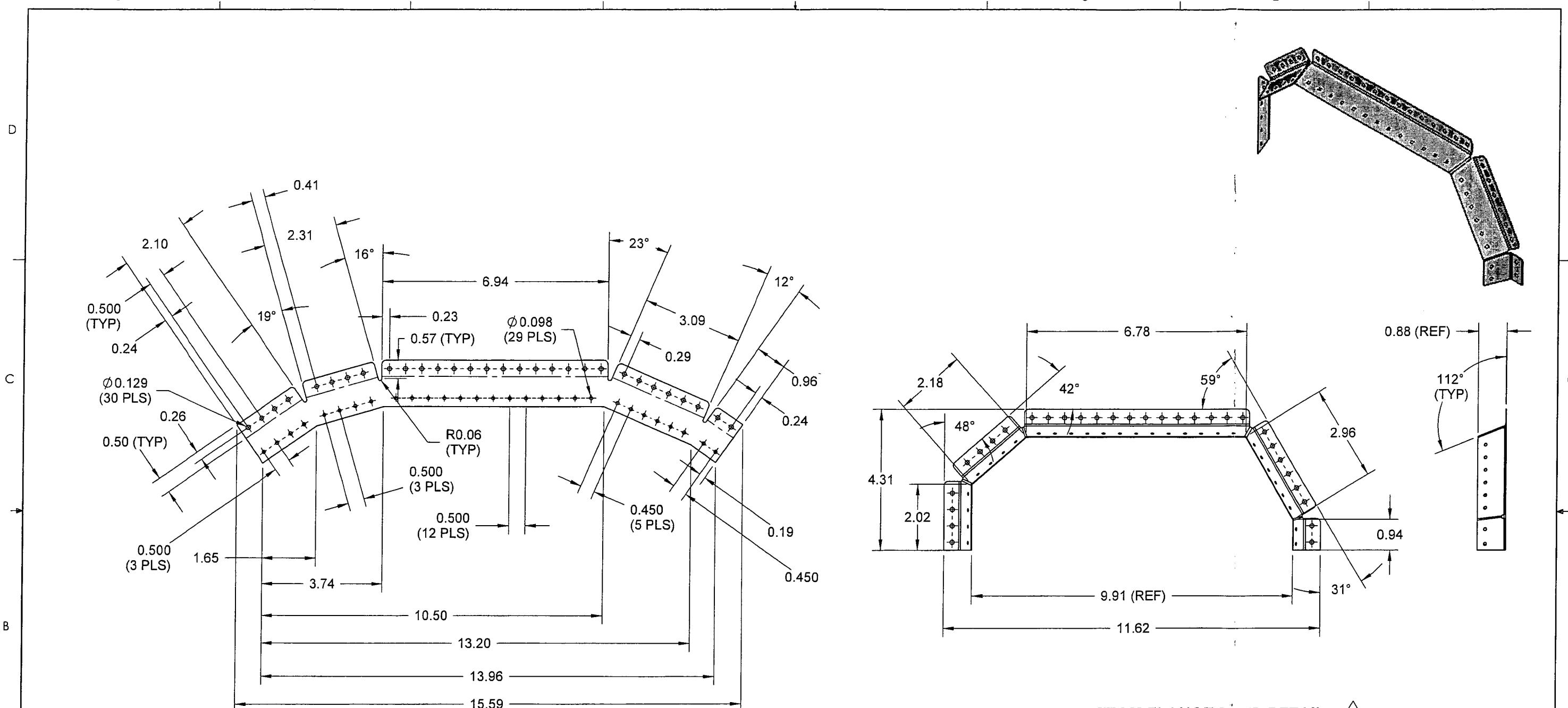
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8 7 6 5 4 3 2 1





8 7 6 5 4 3 2 1



D3651-7 BOTTOM FLANGE BEND DETAIL
(MAKE FROM D3651-7F FLAT PATTERN)

D3651-7F FLAT PATTERN ▲

NOTES:

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- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	ME	DRAWING NO.
MFG. APPR.	ME	REV. B
APPROVED	ME	D3651
DE APPR.	ME	SHEET 6 OF 9
DATE	08.01.07	TITLE
		SCALE
		1:3
		AFT BASE ASSEMBLY

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